

Work Order ID 79102

January-26-12 7:43:51 AM

*gry today 26/01*

\*79102\*

Page 1

Item ID: D3208-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Filler

Start Date: 1/19/12

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 2/02/12

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00

\*100\*

SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.750" x 4.300" Identify for D3208-7

*SA / FF 12-01-26 10*

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-7

*FF 12-01-26 SA*

*10*

120

0.00

\*120\*

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-7 Polish any marks on part within 01. of Dwg D3208

*SA 12/01/26 10*



# Work Order ID 79102

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**\*79102\***

Page 3

Item ID: D3208-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Filler  
 Start Date: 1/19/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 2/02/12 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>202</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

12/1/66 J (10)

12/1/30 J

12-01-27 (10)

# Picklist Print

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Page 1

Work Order ID: 79102

Parent Item: D3208-7

Parent Item Name: Filler

Start Date: 1/19/12

Required Date: 2/02/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B04.05.25Material changed for Step 4KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	134.3184	0.0902	0.9494737			

FD. 12-01-26

Location

Loc Qty

Loc Code

MAT022

134.318421

117684

26.318421

120196

108

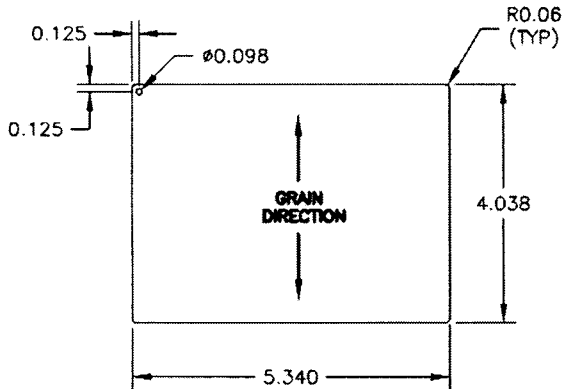
10



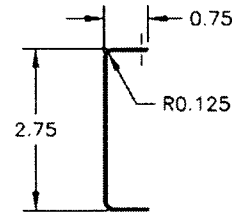
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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED  
040405 #

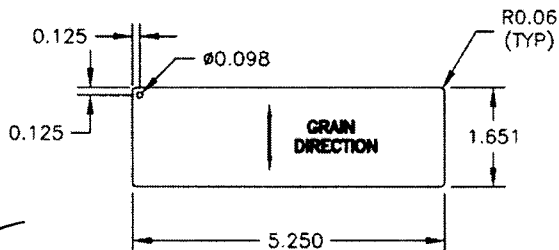
A  
AI # 040127 NEW ISSUE  
# 040125



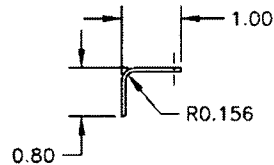
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



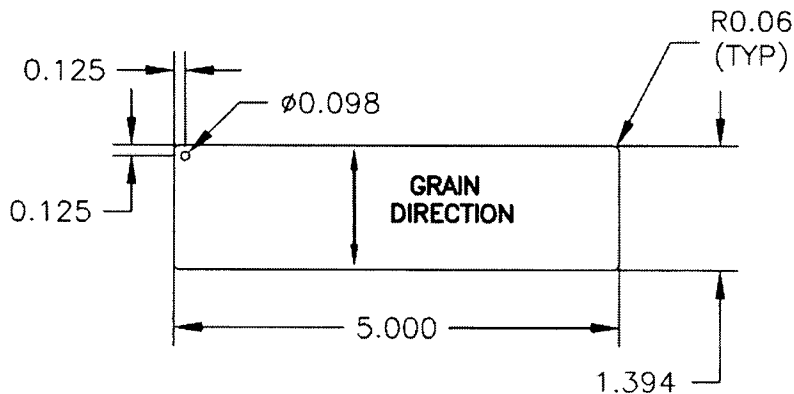
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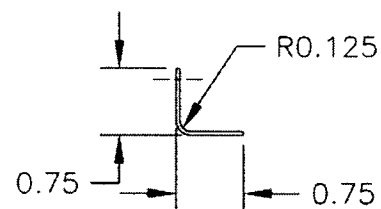


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

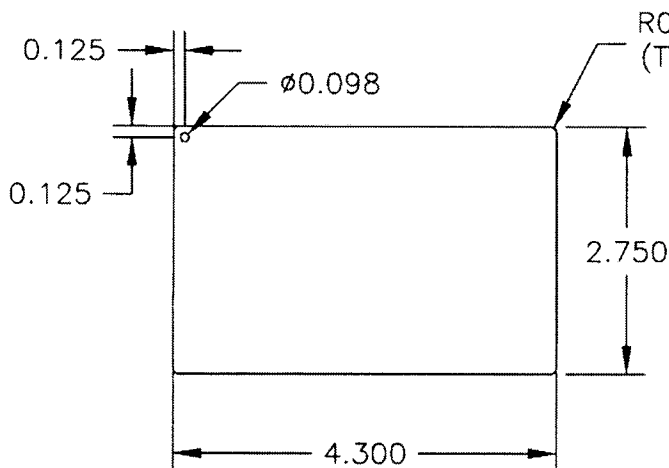
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04.04.05



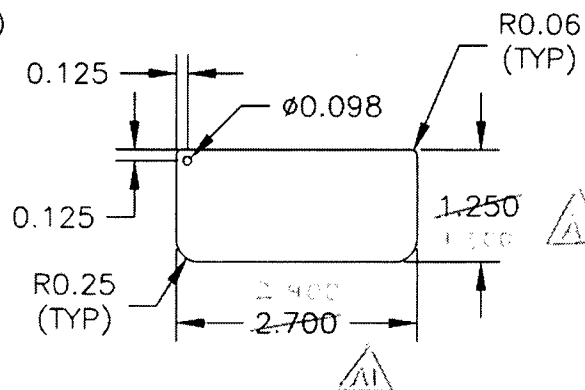
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

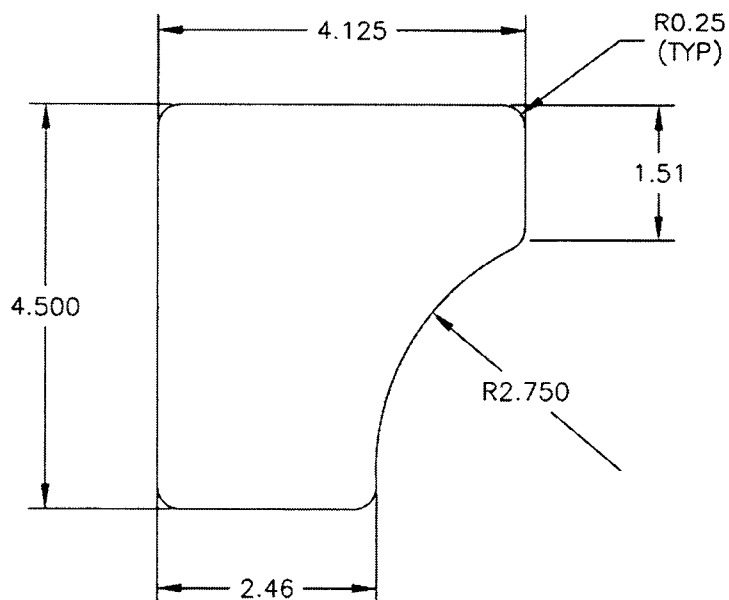
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**D3208-9 DOUBLER**

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